Each

Tuesday, 1/31/2006 11:01:49 AM Date: Kim Johnston User: **Process Sheet Drawing Name** : GHW MEDIUM BELL : CU-DAR001 Dart Helicopters Services Customer Job Number : 25680 **Estimate Number** : 12129 : D412729041 : NIA Part Number P.O. Number S.O. No. : N/A . DSK 092 REV B **Drawing Number** : 1/31/2006 This Issue : N/A Project Number : NC Prsht Rev. : N/A : LARGE FAB ASSY **Drawing Revision** Type First Issue : NIA :NIA Material **Previous Run Due Date** : 2/28/2006 Qty: 1 Um: Written By Checked & Approved By : Est Rev:E 05.04.13 LPS3 rust inhibitor added; Hardware P/N's Comment changed KJ/JLM **Additional Product** Job Number: Description: **Machine Or Operation:** Seq. #: Decal D27287 1.0000 Each(s)/Unit Total: Comment: Qty.: 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2728-7 Label D27554 PC 06.08.14 D3233041 Wheel Assembly 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Comment: Qty.: Pick: **Qty Part Number** Description Batch 2 D3233-041 Wheel Assembly Pl 06.09.19 D32331 Inside Washer 3.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3233-1 Inside Washer 3230 40 Pl 06.09.19

D32333 4.0

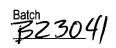
Outside Washer



2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

**Qty Part Number** Description 2 D3233-3 Outside Washer



CPC06.09.19

Dart Ae	rospace L	td								
W/O:			W	ORK ORDER CH	IANGES		<del></del>			
DATE	STEP	PR	OCEDURE CH			Ву	Date	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cat	egory:	NC	R: Yes	No DQ	<b>\</b>	Date: _	
						QA: N	C Close	d:	_ Date: _	
NCR:		,	WORK OR	DER NON-CONFO	DRMANCE	(NCR	)			
DATE	STEP	Description of NC	Initial	Corrective Action Action Descrip	Section B	Sign &	Verific		Approval	Approval
		Section A	Chief Eng	Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector
								•		
	1		1				ĺ			1

Tuesday, 1/31/2006 11:01:49 AM Date: **Process Sheet** User: Kim Johnston Drawing Name: GHW MEDIUM BELL Customer: CU-DAR001 Dart Helicopters Services Part Number: D412729041 Job Number: 25680 Job Number: Seq. #: Description: **Machine Or Operation:** D33091 Label 5.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Description Batch **Qty Part Number** 722104 1 D3309-1 Label CP(06.08.14 D33093 6.0 Comment: Qtv.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: **Qty Part Number** ¶ D3309-3 Label 06-09-19 D3330041 Frame Weldment 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Comment: Qtv.: **Qty Part Number** Description 1 D3330-041 Frame Weldment 06.08.14 8.0 D3331041 Handle Assembly Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Qty Part Number Description Batch
1 D3331-041 Handle Assembly 3230693 CPL 06-08-14 9.0 D3332041 Pin Assembly 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Comment: Qty.: Pick: **Qty Part Number** Description Bato 1 D3332-041 Long Pin Assembly 23770 COL 06-08-14

Dart Aerospace Ltd
--------------------

W/O:			WC	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto	
Part No:		PAR #:	Fault Categ	jory:	_ NCR: Yes	No DQ	A:	Date:		
QA: N/C Closed:						d:	Date: _			
NCR:			WORK ORDE	ER NON-CONFORM	ANCE (NCF	₹)				
DATE	STEP	Description of NC			ion B	Verific	Verification A		Approval	
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section	on C	Chief Eng	QC Inspector	
					,	:				
									:	
		7								

Tuesday, 1/31/2006 11:01:50 AM Date: Kim Johnston User: **Process Sheet** Drawing Name: GHW MEDIUM BELL Customer: CU-DAR001 Dart Helicopters Services Job Number: 25680 Part Number: D412729041 Job Number: Description: Seq. #: Machine Or Operation: D3332043 Pin Assembly 10.0 1.0000 Each(s) 1.0000 Each(s)/Unit Total: Comment: Qty.: Pick: Qty Part Number Description Batch CPL 06.08.14 1 D3332-043 Short Pin Assembly 4 D33331 11.0 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Comment: Qty.: Pick: Qty Part Number Description Batch
1 D3333-1 Base Plate 3 23055 DPC 06-08-14 Sliding Plate D33333 12.0 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Comment: Qty.: Pick: Qty Part Number CP6 06.08.14 Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: Qty Part Number Description Batch 4 D3333-5 Rail 873056 Cpc 06.08.14 14.0 D33341 Wheel Shaft Comment: Qty.: Total: 2.0000 Each(s) 2.0000 Each(s)/Unit Pick: **Qty Part Number** Description Batch CP1 06.09.19 2 D3334-1 Wheel Shaft 325685

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROC	EDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
	:		ı									
1												
Part No	•	PAR #:			NCR: Yes	No DQ	A:	Date:				
		QA: N/C Closed:										
NCR:		W	ORK OR	DER NON-CONFORMA	NCE (NCR	)						
DATE	STEP	Description of NC		Corrective Action Section			cation	Approval	Approval			
	O L	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	ion C	Chief Eng	QC Inspector			
,												
			:									
					:							
	·   											

Tuesday, 1/31/2006 11:01:50 AM Datě: Kim Johnston User: **Process Sheet Drawing Name: GHW MEDIUM BELL** Customer: CU-DAR001 Dart Helicopters Services Part Number: D412729041 Job Number: 25680 Job Number: Description: Seq. #: **Machine Or Operation:** Short Spring D33351 15.0 Total: 1.0000 Each(s) Comment: Qtv.: 1.0000 Each(s)/Unit Pick: **Qty Part Number** Description, Batch 1 D3335-1 Short Spring '**B2ZZS** PPL 06.08.14 D33353 Long Spring 16.0 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Comment: Qty.: Pick: **Qty Part Number** Description Batch 1 D3335-3 Long Spring **B2225**6 PP( 06.08.14 D33361 Inventory 17.0 1.0000 Each(s) Comment: Qty.: 1.0000 Each(s)/Unit Total: Pick: Description Batch **Qty Part Number** 1 D3336-1 PL06.08.14 Washer AN960JD416 18.0 2.0000 Each(s) Comment: Qty.: 2.0000 Each(s)/Unit Total: Pick: Description Batch **Qty Part Number** PPL 06.08.14 Washer M 2 AN960JD416 1/8" Cotter Pin 2" long 19.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Description Batch **Qty Part Number** PL 06-08-19 2 CP-21 1/8" Cotter Pin 2" long, Span j

Dail AC	ospace	Ltu								
W/O:			WC	RK ORDER CHANG	ES					
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	By Date Qty			Approval QC Inspector	
Part No	):	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:		
					QA: I	N/C Close	d:	_ Date: _		
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	₹)				
		Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	ion C	Approval Chief Eng	QC Inspector	
									:	
								:		

Tuesday, 1/31/2006 11:01:50 AM Date: Kim Johnston **Process Sheet** User: Drawing Name: GHW MEDIUM BELL Customer: CU-DAR001 Dart Helicopters Services Part Number: D412729041 Job Number: 25680 Job Number: Description: Seq. #: **Machine Or Operation:** 1/4-20 UNC x 1" Hex Bolt 20.0 HC12 1.0000 Each(s) Comment: Qty.: 1.0000 Each(s)/Unit Total: Pick: Qty Part Number Description Batch 1 HC-12 1/4"-20 UNC x 1" long Hex Bolt, Span CPL 06.09-19 5/16-18 UNCx1.5 Hex Bolt 21.0 HC29 16.0000 Each(s) 16.0000 Each(s)/Unit Total: Comment: Qty.: Pick: **Qty Part Number** Description Batch M19705 16 HC-29 5/16"-18 UNC x 1.5" long Hex Bolt, Prof pl 06.08.14 3/8"-24UNFx1,25 Hex Bolt 22.0 HC153 Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s) Pick: Description Batch **Qty Part Number** 8 HC-1533/8"-24 UNF x 1.25" long Hex Bolt, Span <u>M17356</u> PP606:09-19 HEX SLOTTED NUT 23.0 HN120 Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Description Batch Qty Part Number 2 HN-1201" Slotted Nut, Prof <u>M 18 (62</u> CPL 06-09-19 5/16-18UNC Nylon LockNut 24.0 HN177 16.0000 Each(s)/Unit Total: 16.0000 Each(s) Comment: Qty.: Pick: Qty Part Number Description Batch CDC 06.08.14

W/O:		WORK ORDER CH	ER CHANGES						
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
ı									

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
			QA: N/C Closed:	Date:

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE STEP		Description of NC		Corrective Action Section B	Verification	Approval	Approval	
		Section A	Initial Chief Eng	nitial Action Description Sign &		Section C	Chief Eng	QC Inspector
ol.09.19	Z 0	Qty Z HN120 Nut scrap.		Destoy 4 replace		E 06.09.19		06.09,19

Tuesday, 1/31/2006 11:01:50 AM Date: Kim Johnston User: **Process Sheet** Drawing Name: GHW MEDIUM BELL Customer: CU-DAR001 Dart Helicopters Services Part Number: D412729041 Job Number: 25680 Job Number: Description: Sea. #: Machine Or Operation: 1/4-20 UNCx3/4 S.H.C.S. 25.0 HX15 Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 HX-15 1/4"-20 UNC x 3/4" long S.H.C.S., Span M(6026 PC06.09-19 Nut 26.0 MS21042L5 Comment: Qty.: 2.0000 Each(s) 2.0000 Each(s)/Unit Total: Pick: Qty Part Number Description Batch 2 MS21042L5 Nut (or -5) M/01648 CPL 06.08-14 1 1/4" Type B Washer 2333 27.0 1.0000 Each(s)/Unit Total: Comment: Qty.: Pick: Qty Part Number Description Batch Pol 06-09-19 3/8" Lock Washer 18SNB 28.0 Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s) Pick: **Qty Part Number** Description Batch 8 18-SNB3/8" Lock Washer, Span <u>M1970</u>5 pl 06.09-19 1/8" PTF Grease Fitting 29.0 113803 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Comment: Qty.: Pick: Description Batch Qty Part Number 2 113-803 1/8" PTF Grease Fitting, Span FPL 06-08-14

<b>Dart</b>			

W/O:		WORK ORDER CHANGES	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	By Date		Qty Approval Chief Eng / Prod Mgr		Approva QC Inspecto				
			-								
						·					
			•	$\sim$							

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date: <u>06/07/2</u>
			QA: N/C C	losed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
	STEP	Description of NC Section A		Corrective Action Section B	Verification	Approval	Annroyal					
DATE			Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector				
		e <sup>r</sup>										
					ļ							
		1.										
				•								
<del></del>		· · · · · · · · · · · · · · · · · · ·										

Date: Tuesday, 1/31/2006 11:01:50 AM User: Kim Johnston **Process Sheet** Drawing Name: GHW MEDIUM BELL Customer: CU-DAR001 Dart Helicopters Services Part Number: D412729041 Job Number: 25680 Job Number: **Description:** Seq. #: **Machine Or Operation:** 30.0 656036 Inventory 16.0000 Each(s)/Unit Total: 16.0000 Each(s) Pick: ଭ୍ୟ Part Number Description Batch 5/16" Type B Flat Washer (Narrow), Prof <u>M 19624</u> CPl 06.08.14 LARGE FABRICATION RESOURCE 1 31.0 LARGE FAB CP60609.19 ABRICATION RESOURCE 1 Comment: LARGE Assemble as per Dwg DSK 092. Apply LPS3 heavy duty rust inhibitor & corrosion (Procyon). Inflate wheel assembly to 90 psi. Ensure that unit goes up and down smoothly after assembly. Install decals last. INSPECT WORK TO CURRENT STEP 32.0 QC5 WORK TO CURRENT STEP Comment: INSPECT PACKAGING 1 PACKAGING RESOURCE #1 33.0 Comment: PACKAGING RESOURCE #1 10 06/09/20 U Ob 09-20 Identify and Stock Location: Job Completion

Dail Ac	Ospace	Liu							
W/O:			WC	RK ORDER CHANG	ES	<u>-</u>			
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		. <del>-</del>							
Part No		PAR #:	Fault Cate	Jory:	NCR: Yes	No DQ	A:	Date:	
					QA: N	I/C Close	d:	Date: _	
NCR:		1	WORK ORDE	ER NON-CONFORMA	NCE (NCF	₹)			
	STEP	P Description of NC Section A	Corrective Action Section			Verificati		n Approval	Approval
DATE			Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	Section C	Chief Eng	QC Inspector
					:				



	,	1	.t					
	DESIGN		DRAWIN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
			ARPROVED	DRAWING NO.	REV. B			
	P	F		DSK 092 <sub>SH</sub>	EET 1 OF 1			
	DATE			TITLE	SCALE			
	05.02.18			HYD. GROUND HANDLING 1:5				
	A	04.12.06		NEW ISSUE				
	В	05.02.18		REDESIGN TO FIT NEW WHEEL ASS'Y	IT NEW WHEEL ASS'Y			

D3309-1 **D3330-17 HANDLE** LABEL (1) HEX BOLT 1/4"-20'x 1" LONG (1) FLAT WASHER 1/4" TYPE B WIDE (1) SOCKET (1) D3331-041 D2728-7 HANDLE ASS'Y (1 D3330-9 TOP LABEL (1) PLATE (1) HEX. SOCKET D3330-5 FRONT PANEL (1) D3330-7 BACK PANEL (1) CAP SCREW 1/4"-20 x 0.75", (NOT SHOWN, SIMILAR TO D3330-5) AN960JD416 FLAT WASHER D3330-15 HANDLE (1)-(2 PLACES) D3309-3 LABEL D3233-041 (2 PLACES) WHEEL ASS'Y (2 PLACES) **D3333-3 SLIDING** PLATE (2 PLACES) D3335-3 LONG D3330-11 SPRING (1) LONG PIN (NOT SHOWN) BRACKET (1) D3332-041 LONG PIN ASS'Y (1) Ø **D3233-1 INSIDE** WASHER (2 PLACES) D3233-3 OUTSIDE WASHER (2 PLACES) 0 0 D3336-1 JACK (1) SLOTTED NUT 0 1"-14 UNF AND D3333-1 BASE PLATE (1) 6 ROUND COTTER PIN 1/8" x 2" LONG D3330-19 HANDLE RIM (1) 0 (2 PLACES) g 8 D3334-1 WHEEL SHAFT D3330-3 (2 PLACES) **BOTTOM** PANEL (1) D3333-5 RAIL (4 PLACES) D3330-1 HEX. BOLT 3/8"-24 UNF x 1.25" LONG REG. SPRING LOCK WASHER 3/8" LEFT PANEL (1) D3332-043 (8 PLACES) SHORT PIN (1) D3330-2 HEX. BOLT 5/16"-18 UNC x 1.50" LONG RIGHT D3335-1 SHORT SPRING (1) SHOP COPY FLAT WASHER TYPE B NARROW 5/16" PANEL (1) STD. HEX. NYLON LOCK NUT 5/16"-18 UNC (NOT SHOWN) ETURN TO (16 PLACES) D3330-13 MS21042L5 NUT ENGINEERING SHORT PIN (2 PLACES) UNCONTROLLED CORY GREASE FITTING 1/8" P.T.F. BRACKET (1) SAE SPEC. EXTRA SHORT SUBJECT TO AMENDMENT (4 PLACES)

NOTE:

1) APPLY RUST INHIBITOR ON ALL PARTS AND AREAS NOT PROTECTED BY PAINT OR GREASE. WORK ORDER RUST INHIBITOR POSSIBLE SUPPLIER: ACKLANDS-GRANGER INC., P/N LPSC30316.

WITHOUT NOTICE

#### COPYRIGHT © 2004 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.